Work Order II Wednesday, June 04,			数	*120	1509*				-			Page 1
Item ID: D3501-1 Revision ID: Item Name: Bushing			Accept	*N900	1 040	10	N*	Setup	Start Stop	171	S1* S2*	
Start Date: 6/04/ Required Date: 6/04/		Start Qty: 240.00	*240*		Cust Item							•
Reference:	14	Req'd Qty: 240.00	*240*	•	Customer	:						
Approvals: Prod	cess Plan	: MLJ	Date: 14-06-09	Tooling:	I	Date:			Run	Start	*N	R1*
QC:			Date:	SPC (Y/N):	I	Date:				Stop	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr										
D3501	Rev A	A										
100				0.00				·	· · · · · · · · · · · · · · · · · · ·			DAS
100		Hardinge CNC LATHE S	MALL					240				25 4_/_
Hardinge Hardinge CNC Lathe Small	I	Memo 1-TURN AS I REV: <u>N</u> /A	PER FOLIO FA650 & DWG DWG REV: A 2-1	9.00 G D3501 ,FOLIO DEBURR AS REQUIRI	ED			Q 10_				- - 9-89 9
ı												
110		QC2- Inspect parts off ma	chine FAI/FAIB	0.00								
110								240				25 H-6-1
QC .		Memo		0.00				₩/V				9-89
Quality Control				: .								
120		QC8- Inspect parts - secon	d check	0.00								
120		200 mspeet parts - secon	IG CHECK	0.00				248				44
QC Quality Control		Memo	į	0.00								14/0 c h3

DQA:			Date:										TRAC
						WORK ORDER NON	-CC	ONFO	RMANCE / UP				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	ar.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
· · · · · ·	٠٠٠,					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					-	Use-as-is		Therr	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	۱o. ِ					Suspected Unapproved]		Large Fab	Composite		Supplier	
Root					Desc	ription of work order update		nitial	Actio	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design								=			,		
Doc/Data													
Equip/Tooling							1						
Handling/Pre													
Material													
Operator さま													ļ
Offset/Setup	2.5												
Process 🤲	-1					_ V							
Supplier		:											
Training													
Transport													
Unapproved				L			EAL	HT CA	TEGORY				l,
Landi						General	FA	OLI CA	IEGORT	.			
Langi	_	Bending				Bend	Г	leolio/s	Program	Γ-	Outside Dim	ensions F	Pressure/Forced
		Centre No	nt Concer	ntric	-	BOM/Route	\vdash	Grain	rogram	<u> </u>	Over/Under	}	Set-up
		Cracks	or concer	itiit		Broken/Damage/Defect		Hardwa	are		Part Incorre		Temperature/Cure
		Crimp/Kir	nk/Rinnle	/Wave	ļ	Burrs	\vdash	4	ion Incomplete/Und	gualified	Part Lost/Mi	issing	Weld
ļ		Cuffs	ng mpp.c	,		Contamination	\vdash	1	tions Incomplete/U		Part Moved		Wrong Stock Pulled
		Crushing				Countersink	<u> </u>	4	gned/off center		Positioned V	Vrong	
	\vdash	Heat Trea			-	Cut Too Short		Mislab			Power Loss/	_	Other
		Inspectio		Tube		Drawing		Misrea	d	_	-		
		Marks/Ch				Drill Holes		Off-set					
		Turning S				Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

Work Ord Wednesday, Ju				*120					Page			
Item ID: Revision ID:	D3501-1			Accept	*N900	<u>040</u>	100)*	Setup S			S1*
Item Name: Start Date: Required Date Reference:	Bushing 6/04/14 2: 6/04/14	Start Qty: 240.00 Req'd Qty: 240.00	-	40* 40*	Cust Item 1 Customer;	ID:				Stop	*N	S2*
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:				Start Stop	*N	R1*
Sequence ID/ Work Center 1 130	ID	Operation Description Identify as per dwg & Stor	ck Location:_5`	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rejec Qty		leject lumber S	Insp. Stamp
120 Packaging		Memo		0.00				240	2X_	28 94	3	JUN 132

0.00

0.00

Memo

Memo

QC21- Final Inspection - Work Order Release

Packaging

140

Quality Control

140

MLD 14.6.16

Page 2

JUN 1 3 2014

DQA:			Date:							•					
						WORK ORDER NON	I-C(ONFO	RMANCE / UF			-	AEROSPACE		
QA Closed:			Date:							W	ork Order u	odate only			
Work Orde	or.					DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Work Orac	-					Rework			Skid-tube	Crosstube]	Water Jet	Engineering		
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	-					Use-as-is	1		noforming	Finishing	-	re/Packaging	Other		
NCR N	No.					Suspected Unapproved	1		Large Fab	Composite		Supplier			
												· ·			
Root					Desc	ription of work order update		nitial	Acti		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector		
Design	\square														
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Equip/Tooling	\dashv														
Handling/Pre															
Material .		•			٠.		1						,		
Operator	\vdash														
Offset/Setup		•											•		
Process	\vdash									•		•			
Supplier															
Training Transport										٠					
Unapproved	\dashv														
,	- , 1						FA	ULT CA	TEGORY		<u>.t.</u>				
Landir	ng G	iear				General		- 1							
	$\overline{}$	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced		
1		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up		
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci	Temperature/Cure		
		Crimp/Kir	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/Un	qualified	Part Lost/M	issing	Weld		
		Cuffs				Contamination		Instruc	tions Incomplete/U	Inclear	Part Moved	L	Wrong Stock Pulled		
	Ш	Crushing				Countersink	\perp	-	gned/off center	<u>_</u>	Positioned \		_		
		Heat Trea				Cut Too Short	<u>_</u>	Mislabe			Power Loss/	'Surge	Other		
	Inspection Strip in Tube		Drawing	L	Misrea										
	Marks/Chatter		Drill Holes		Off-set										
	Turning Sequence			Finish	\vdash	4	Calibration								
	Wave/Twist in Tube				Fit/Function		Out of	Sequence							

Page 1

Work Order ID: 120509

120509

Parent Item:

D3501-1

D3501-1

Parent Item Name: Bushing

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 240.00

Required Qty: 240.00

Comments:

IPP Rev:A New Issue 06-05-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No		100	f	182.5610	0.0791	20			-
Manarn	75 0							**		. t	11/10	-

303 Round Bar 0.750

Location	Loc Oty	Loc Code	
MAT028	182.561		
m127464	48.948		
m128882	0.196		
m129237	37.417		
m129366	96		420

DQA:			Date:						_				
			D.1.			WORK ORDER NON	I-C(ONFO	RMANCE / UP		Nork Ordor III	adata anku [AEROSPACE
QA Closed:			Date:								Vork Order u	date only	
Work Orde	r:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	-					Rework Skid-tube Crosstube			Crosstube	7	Water Jet	Engineering	
Part N	o.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•				_	Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR N	ο.					Suspected Unapproved	1		Large Fab	Composite		Supplier	
	-						_				,		
Root					Desci	ription of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design													
Doc/Data												·	
Equip/Tooling	_												
Handling/Pre	_												
Material	4									•			
Operator							1						
Offset/Setup	_												
Process	\dashv												
Supplier						•				-		ļ	
Training	_									•			
Transport Unapproved	\dashv						ļ			•			
Oliappioved							FA	ULT CA	TEGORY			<u> </u>	
Landin	e G	iear				General							
Г	_	Bending				Bend		Folio/f	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí _	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/U	nclear	Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned \	_	``
[Heat Trea	at		L	Cut Too Short		Mislab			Power Loss,	'Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea			 		
		Marks/Ch				Drill Holes	\perp	Off-set					
		Turning S			<u> </u>	Finish	_	4	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

DART AEROSPACE L	TD			Work Order:	120509
Description: Bushing				Part Number:	D3501-1
		•			
Inspection Dwg: D3501	Rev: A		, a #5		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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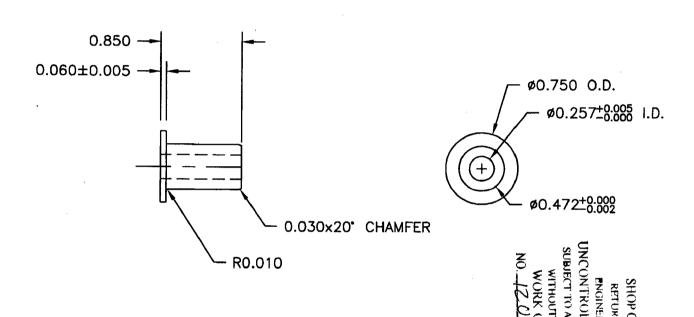
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.850	+/-0.010	-850			18TM	SL-10
0.060	+/-0.005	-061			^	
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Ø0.257	+0.005/-0.000	258			~	
Ø0.472	+0.000/-0.002	1441			nic	N-H
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Measured by:	Audited by:	14	Prototype Approval:	N/A
Date: 14-6-12	Date:	M/06 [13	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.10.27	New Issue	KJ/JLM OK	
				

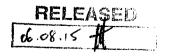


DESIG	P	DRAWN BY		AEROSPACE LTD WKESBURY, ONTARIO, CANADA
CHEC	KED	APPROVED IN	DRAWING NO.	REV. A
	#	90	D3501	SHEET 1 OF 1
DATE		TITLE	SCALE	
06.04.18		BUSHING	1:1	
Α		06.04.18	NEW ISSUE	



D3501-1 BUSHING

- 1) MATERIAL: AISI 303 SS (REF DART SPEC. M303R)
- FINISH: NONE
- BREAK ALL UNMACHINED SHARP CORNERS 0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



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